Date: Friday, 11/16/2007 7:21:11 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL ROTOR PEDAL DISABLING KIT
Job Number	: 35806		
Estimate Number	: 12334		
P.O. Number	: N/A	Part Number	: D3371041
This Issue	: 11/16/2007 S.O. No. : N/A	Drawing Number	: D3371 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 33814	Material	: N/A
Written By	:	Due Date	: 12/20/2007 Qty: 6 Um: Each
Checked & Approved By	: 07/11/16		
Comment	: Est Rev: A Removed from 9 Digit 06-03-10 KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D33711	Pedal Lock Base

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3371-1	Pedal Lock Base	B22287A

AS 07/12/05 (x6)

Seq. #:	Machine Or Operation:	Description :
2.0	D33713	Pedal Lock Cover

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3371-3	Pedal Lock Cover	22288

AS 07/12/05 (x6)

Seq. #:	Machine Or Operation:	Description :
3.0	D33853	Hinge

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3385-3	Hinge	22387

AS 07/12/05 (x6)

Seq. #:	Machine Or Operation:	Description :
4.0	POWDER COATING	POWDER COATING

Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

N/A

Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT

N/A

Form: mprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:21:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 35806
Part Number: D3371041

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

6.0 D27287 Decal

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2728-7	Decal	B22554

AS 04/12/05 (x6)

7.0 D33737 Cam Lock

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3373-7	Cam Lock	B22944

No quantities.

8.0 AN526C832R6 Screw

Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN526C832R6	Screw	~~M16616~~ M16612

AS 04/12/05 (x6)

9.0 238028 3/16" Dowel Pin .5" long

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	238-028	3/16" dia. Dowel Pin 1/2" long	M17848
A/R	N/A	Locktite 262	M104483

AS 04/12/05 (x6)

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Press dowel pins as per Dwg D3371, then assemble hinge.Ensure that assembly opens & closes smoothly. Identify as D3371-051.
2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	M104483

SAD 02-12-10 (6)

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:21:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** TAIL ROTOR PEDAL DISABLING KIT

Job Number: 35806 **Part Number:** D3371041

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	D33841	Cyclic Sock

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:
Qty Part Number Description Batch B35833 (x2)
1 D3384-1 Cyclic Sock B26372 (x4) AS 07/12/05 (x6)

-2 *

Seq. #:	Machine Or Operation:	Description :
12.0	CBL460	Loop Sleeve

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 CBL-460 Loop Sleeve M103927 AS 07/12/05 (x6)

PTO →

Seq. #:	Machine Or Operation:	Description :
13.0	CBL1240	Cable

Comment: Qty.: 1.7499 f(s)/Unit Total : 10.4996 f(s)
Pick:
Qty Part Number Description Batch
20" CBL-1240 Cable M103927 AS 07/12/05 (x6)

Seq. #:	Machine Or Operation:	Description :
14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045 SAD 07-12-10

Seq. #:	Machine Or Operation:	Description :
15.0	AN960416	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 AN960-416 Washer M5519 AS 07/12/05 (x6)

Seq. #:	Machine Or Operation:	Description :
16.0	HX81	1/4"-20 SHCS 3/8" long

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 HX-81 1/4"-20 SHCS 3/8" long M16971 AS 07/12/05 (x6)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/12/13

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B				
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
07-12-11	12.0	One was damage and had to be removed xCBL-460. was crimped befor the loop was full installed RC. Human error	05/11/12	Scrap, destroy replace 1 CBL-460 Loop Sleeve	Sad 07-12-10	11/12/12	05/11/12	11/12/12

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Friday, 11/16/2007 7:21:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL ROTOR PEDAL DISABLING KIT

Job Number: 35806

Part Number: D3371041

Job Number:

Seq. #:	Machine Or Operation:	Description :
17.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.
Identify as D3371-041 & attach keys
Record the Key Number on page 4

SAD 07-12-11 (6)

Seq. #:	Machine Or Operation:	Description :
18.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

07/12/12 (6) coails

Seq. #:	Machine Or Operation:	Description :
19.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_______

Record Key #

C420A 6X

1/12/12

Seq. #:	Machine Or Operation:	Description :
20.0	QC21	FINAL INSPECTION/W/O RELEASE

(6)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/12/13

Job Completion

St 487 07/12/12 (X6)

2007/12/12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

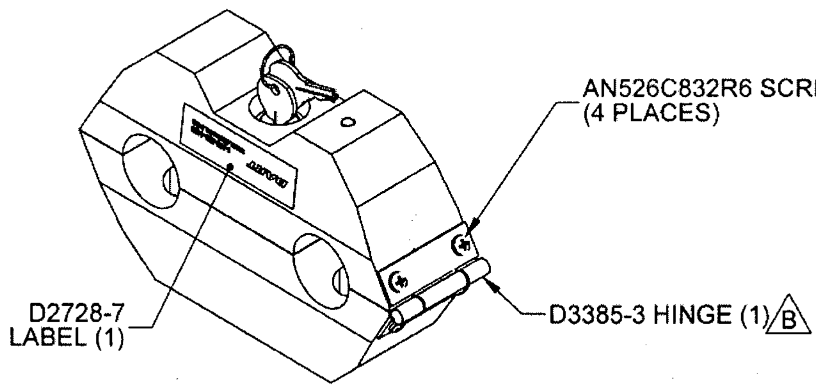
QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

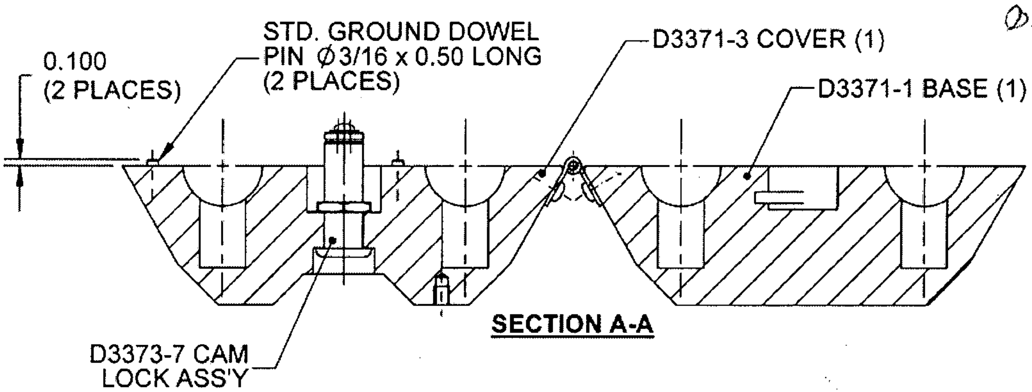
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3371 — REV. B — SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK — SCALE 1:3

REV	DATE	DESCRIPTION
A	04.12.06	NEW ISSUE
B	05.03.22	D3385-3 WAS D3385-1

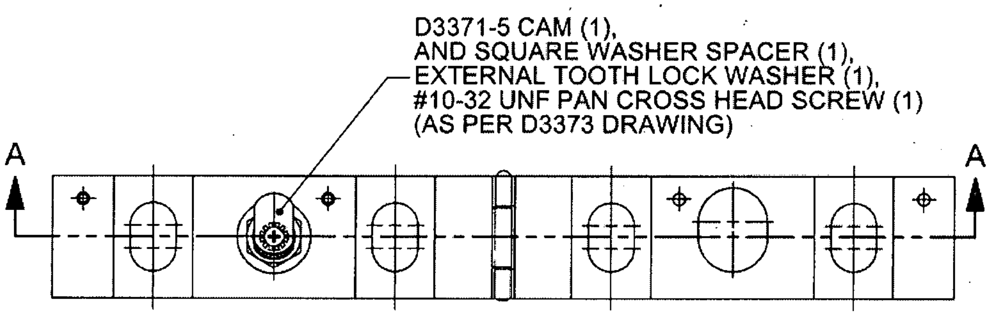


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED 05/04/28



SECTION A-A



D3371-051 PEDAL LOCK ASSEMBLY

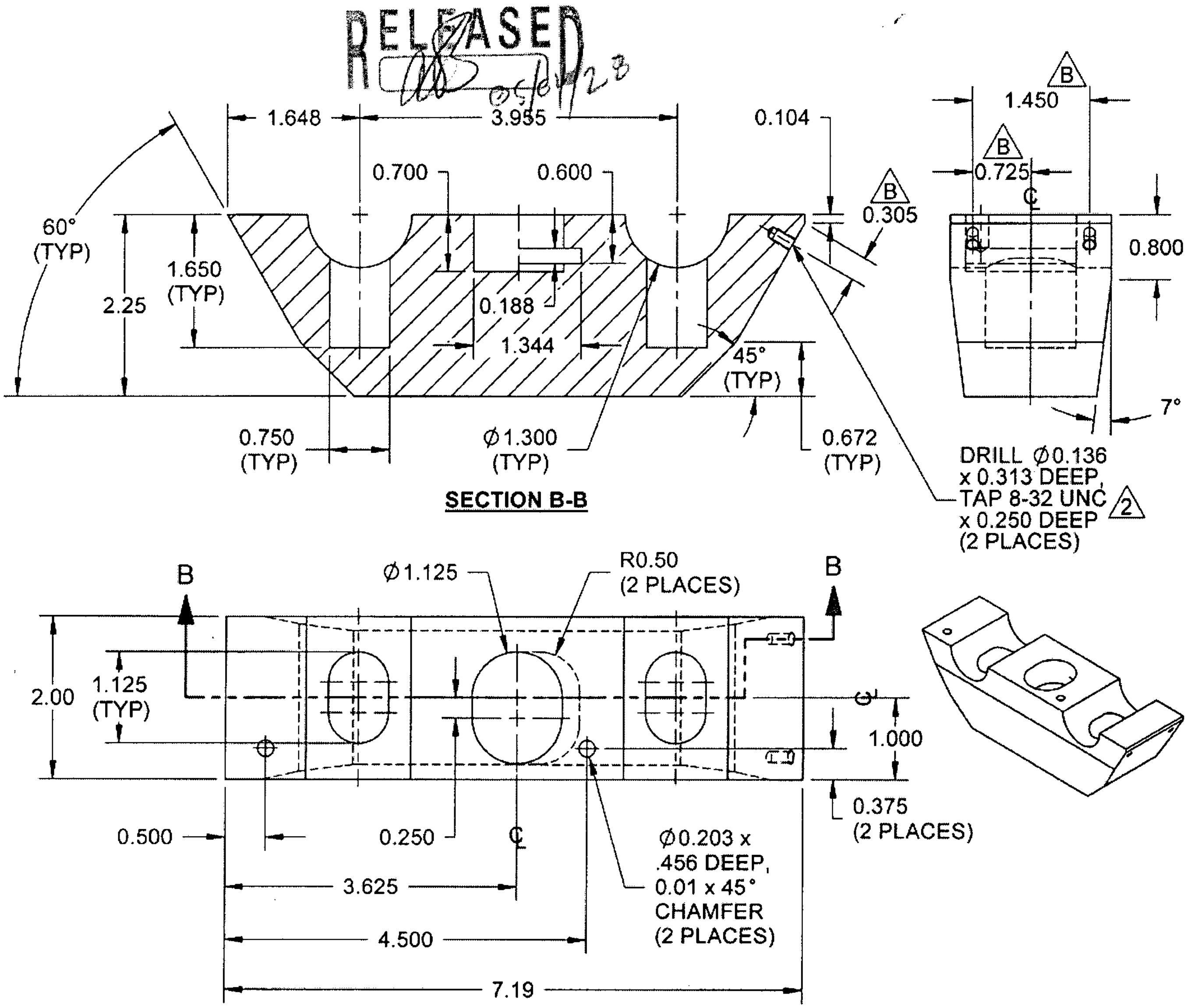
SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 35806

NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3371 — REV. B — SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK — SCALE 1:2

DART



D3371-1 BASE

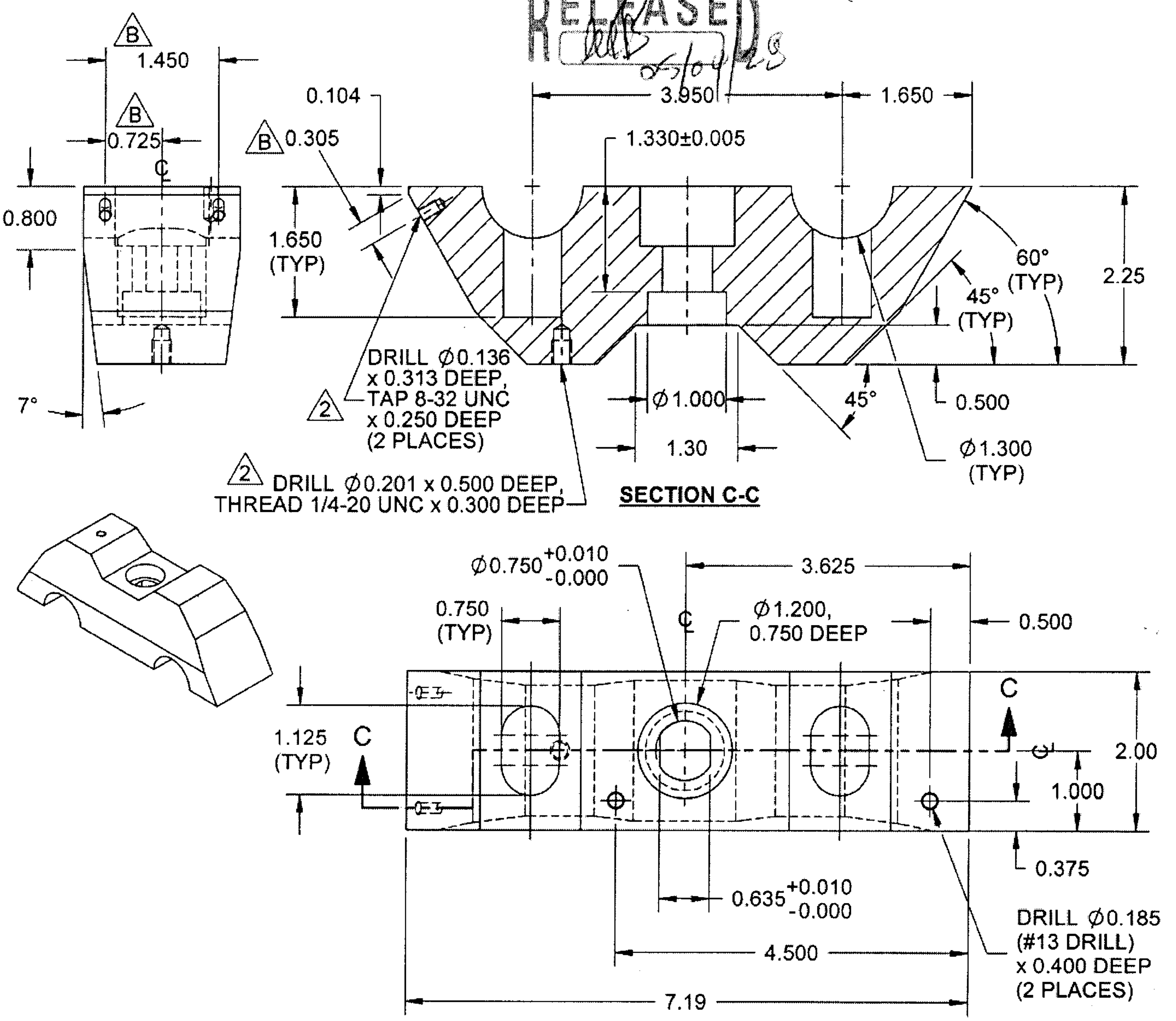
NOTES:

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 35806

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3371 — REV. B — SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK — SCALE 1:2

RELEASED



D3371-3 COVER

NOTES:

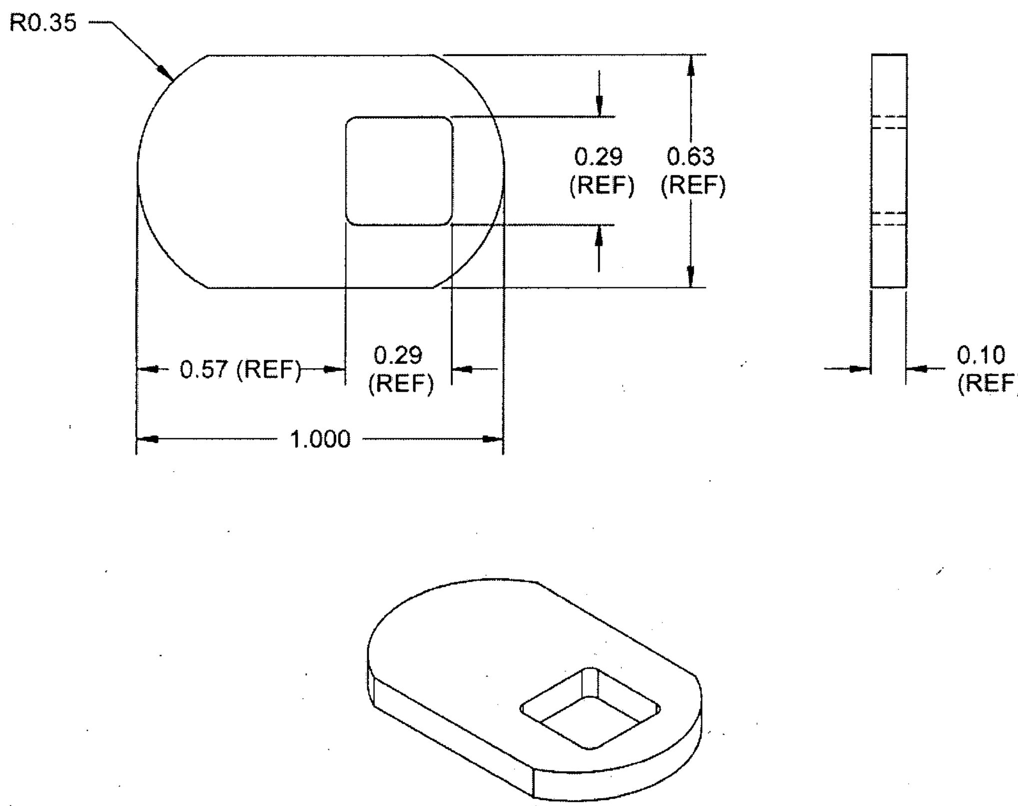
1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
   (REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 35806

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE		TITLE	SCALE
05.03.22		PEDAL LOCK	2:1

RELEASED 05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

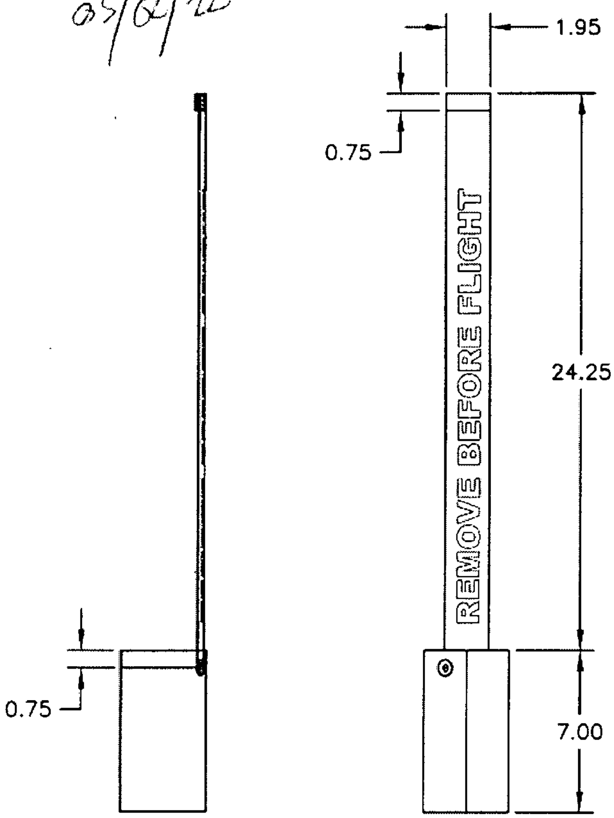
1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

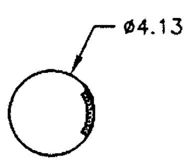
SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 35806

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3384 — REV. A — SHEET 1 OF 1
DATE 05.01.20		TITLE SOCK ASSEMBLY — SCALE NTS

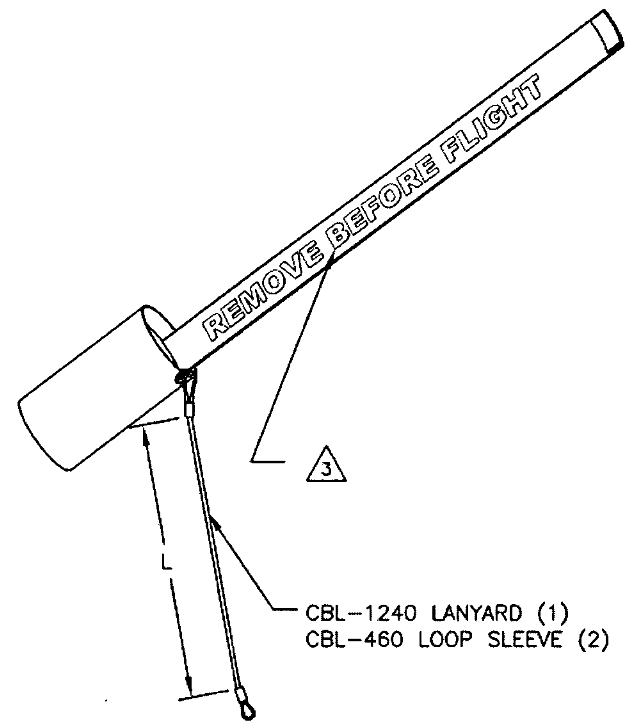
REV		DATE	DESCRIPTION
A		05.01.20	NEW ISSUE
A1		05.04.19	ADDED D3384-049

RELEASED 05/02/22





D3384-1 SOCK



D3384-0XX

P/N D3384-0XX	L (in)
D3384-041	24
D3384-043	8
D3384-045	20
D3384-047	28
D3384-049	30

NOTES:
1) POSSIBLE SUPPLIER: TULMAR
2) THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH
3) STENCIL THE FOLLOWING: REMOVE BEFORE FLIGHT ON BOTH SIDES OF STRIP WITH 1" LETTERS
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED